

Work Order ID 85107***85107***

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Friday, June 01, 2012 4:04:40 PM

Item ID: PB67-43001-37

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Tube Arm Assembly

Stop ***NS2***

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-06-40*

Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

c

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- assemble by drilling thru both -125 and -343 as per dwg
2- install spring slotted pin as per dwg

①

φ

Ae

12.06.05

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

S. L. L. L. L. L.

②

120

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

120

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-15

320

8-45

0.00

1X φ

MA

12/06/13

M 18144

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

14 12/06/13

140

Identify as per dwg & Stock Location: 726

0.00

140

Packaging

Memo

0.00

Packaging

1 sac 12/06/13

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/14
MCJ 12/06/13

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 85107

Parent Item: PB67-43001-37

Parent Item Name: Tube Arm Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	82.0000	1	1		Ac 12.06.13	

Location

Loc Qty

Loc Code

ST400

82

115827

82

PB67-43001-125

Manufactured

No

100

Each

2.0000

1

1

Ac 12.06.13

Clevis

Location

Loc Qty

Loc Code

Mezz

2

23993

2

PB67-43001-343

Manufactured

No

100

Each

10.0000

1

1

Ac 12.06.13

Tube Arm

Location

Loc Qty

Loc Code

ST432

10

41213

6

41507

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

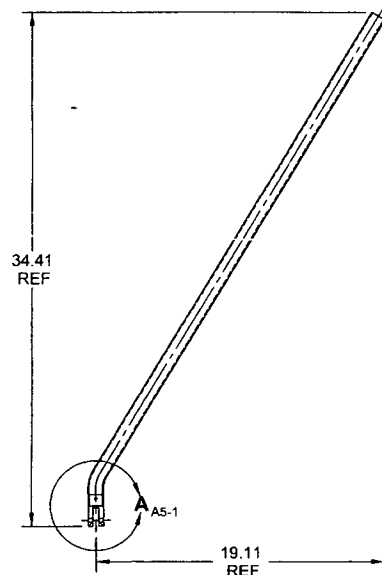
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

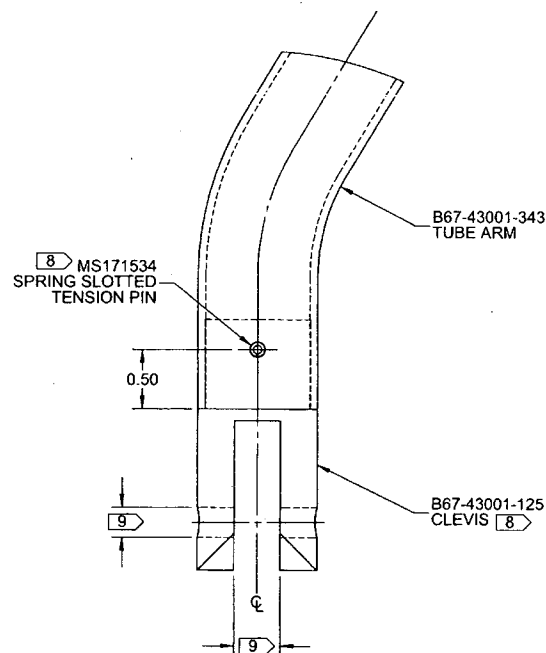
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ITEM	QTY -37	P/N	DESCRIPTION
1	X	B67-43001-37	TUBE ARM ASSEMBLY
3	1	B67-43001-343	TUBE ARM
4	1	B67-43001-125	CLEVIS
5	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-37 TUBE ARM ASSEMBLY



DETAIL A B7-1
SCALE 4 X

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.81 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-125 ON B67-43001-343 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-125 TO B67-43001-343 USING MS171534 SPRING SLOTTED TENSION PIN
- 9) MASK PRIOR TO POWDER COAT

#85107
RELEASED
2009-09-24

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	ASS	DRAWING NO.	B67-43001-37	REV. C
MFG. APPR.	AD	SHEET 1 OF 1		
APPROVED	AW	TITLE	TUBE ARM ASSEMBLY	SCALE
DE APPR.	N/A	NTS		
DATE	09.06.24	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
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